

Ship 23/08

Work Order ID 164881

164881

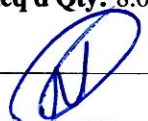
Page 1

Friday, August 04, 2017 4:15:15 PM

Item ID: D5238-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lower Bracket, Aft

Start Date: 8/10/2017 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 8/14/2017 Req'd Qty: 8.00 *8* Customer:

Reference:

Approvals: Process Plan:  Date: AUG 08 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5238	B								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.08							
Packaging									
110		0.00							
110									
Small Fab	Memo	4.15							
Small Fab	INSTALL HELI-COIL FLUSH AS PER DWG AND NOTE 9								
	TORQUE BOLT TO 160-190 in LBS, AS PER DWG NOTES 8								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.08							
Quality Control									

8

DAS 6 9-89

AUG 22 2017

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NU

17-8-23

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DAS 38 9-89

AUG 24 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: 5745	0.00				8			
130									
Packaging	Memo	0.08							
Packaging									
140	QC21 - Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.80							
Quality Control									

AUG 24 2017

DAS 21 9-89

AUG 24 2017

DAS 21 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 1

Work Order ID: 164881

164881

Parent Item: D5238-043

D5238-043

Parent Item Name: Lower Bracket, Aft

Start Date: 8/10/2017

Required Date: 8/14/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 15.05.21 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5237-1		Manufactured	No			100	Each	0.0000	1	8			
D5237-1									**				
Bracket													
D5245-5		Manufactured	No			100	Each	20.0000	1	8			
D5245-5									**				
Mounting Bolt													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST160	20							
					160620	20							
MS21209-F610		Purchased	No			100	Each	50.0000	1	8			
MS21209-F610									**				
Heli-Coil													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST296	50							
					m137391	8							
					m137633	42							

16-1884

AUG 22 2017

DAS

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9-89

DAS

6

9-89

AUG 22 2017

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DAS

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9-89

AUG 22 2017

8

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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
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